



# Work Order ID: 74023

Tuesday, September 20, 2011 12:59:50 PM


Page 1


Item ID: D2013-4	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Mirror Bracket RH, 212					
Start Date: 9/20/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 10/3/2011	Req'd Qty: 6.00		Customer:		
Reference:					


Approvals:	Process Plan: <u>  <i>L</i>  </u>	Date: <u>11-09-20</u>	Tooling:	Date: <u>          </u>	Run	Start	
	QC: <u>                  </u>	Date: <u>                  </u>	SPC (Y/N): <u>                  </u>	Date: <u>                  </u>		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2013	Rev C

100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Punch as per template D2013-T3 and Dwg D2013								
	2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545								
	3-Bend (1) tube as per Dwg D2013 using Jig DT8201								
	Identify as D2013-3.								
	4-Deburr as required								

*SP* 11/12/12   
*Ac* 11.12.11

110	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

*S* 11/12/13

  
*RY*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74023**

Tuesday, September 20, 2011 12:59:50 PM

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Item ID: D2013-4

Accept

Revision ID:

Item Name: Mirror Bracket RH, 212

Start Date: 9/20/2011 Start Qty: 6.00

Required Date: 10/3/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Identify as per dwg & Stock Location: **W40254**

0.00



Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

**x7** **11-12-13****11/12/14****11-12-14**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 1:00:06 PM

Page 1

Work Order ID: 74023

Parent Item: D2013-4

Parent Item Name: Mirror Bracket RH, 212



Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	98.3496	1.9473	12.29874			
304 RD Tube .750 x .049W													

## Location

## Loc Qty

## Loc Code

MAT017

98.34963

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117797

0.75

117983

7.091

118390

55.59263

SA 11/02/09

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

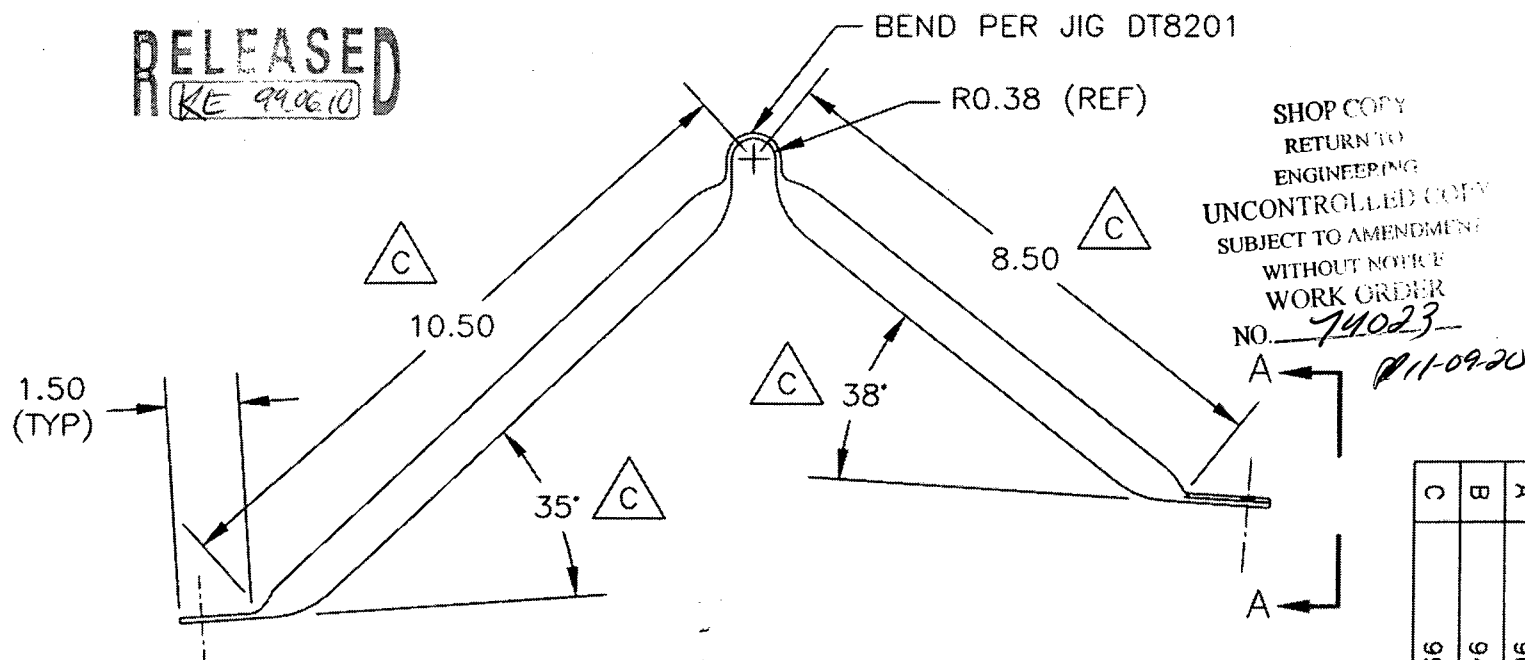
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

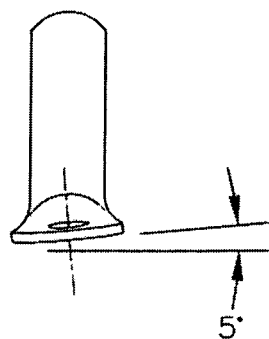
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
KE 99.06.10



D2013-1 LH SHOWN  
D2013-2 RH OPPOSITE  
(FOR 205 MIRROR)



VIEW A-A

DRILL  $\phi 0.257$  (TYP)

0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 OD x 0.049 WALL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74023

01-09-20

**DART**



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	JD	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 1 OF 3
				SCALE NTS
	A	90.10.22	NEW ISSUE	
	B	94.06.15	REDRAWN	
	C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

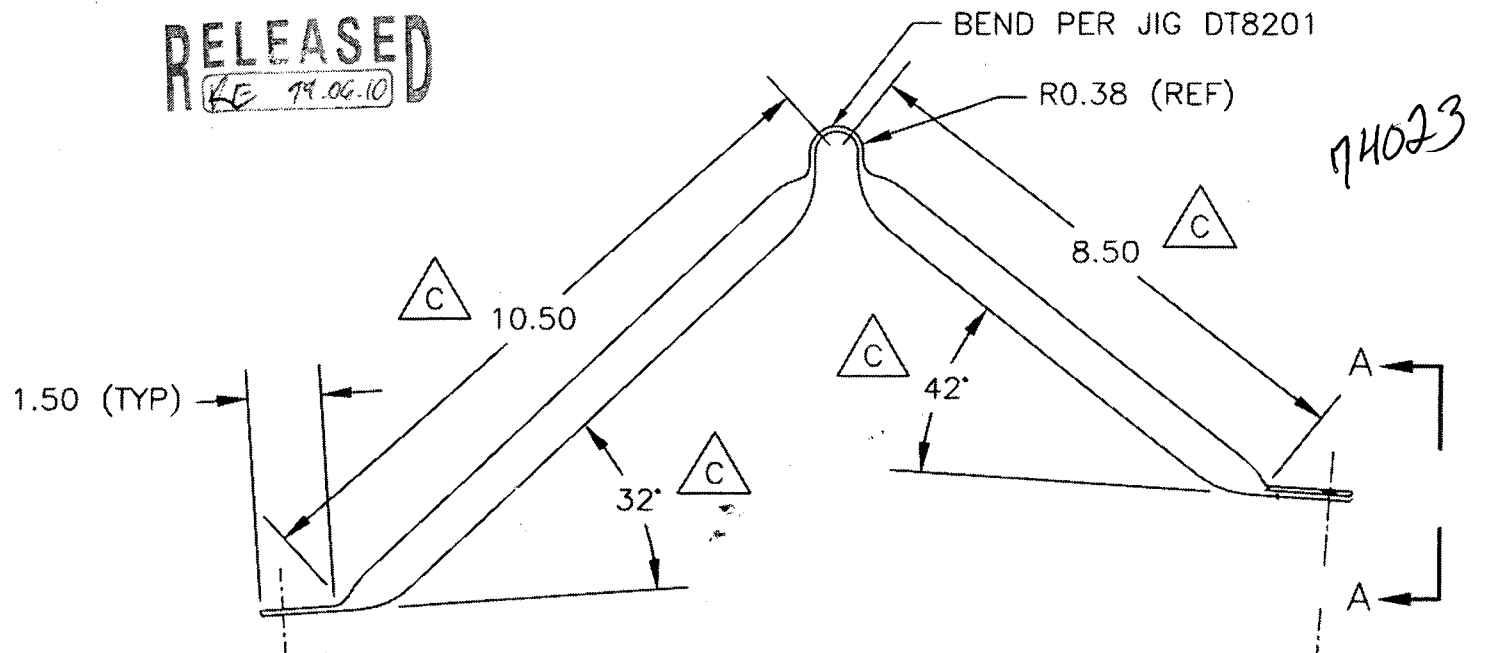
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

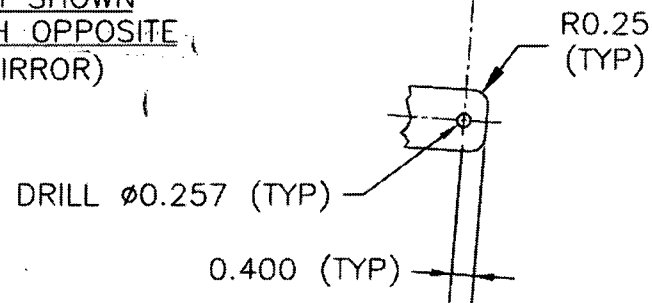
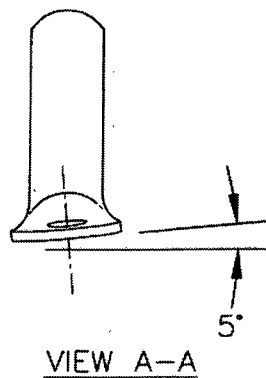
**NOTE:** Date & initial all entries



RELEASED  
KE 79.06.10



D2013-3 LH SHOWN  
D2013-4 RH OPPOSITE  
(FOR 212 MIRROR)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL

**DART**

QA COPY  
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	[Signature]	D2013
DATE	TITLE	REV. C
99.06.07	MIRROR BRACKET	SHEET 2 OF 3
		SCALE N15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

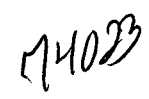
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RE 99.06.10



DESIGN	JB	UNION	RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	✓	DRAWING NO.	REV. C
				D2013	SHEET 3 OF 3
DATE	99.06.07			TITLE	SCALE
				MIRROR BRACKET	NTS



DRILL Ø0.257 (TYP) ———— (TYP)  
0.400 (TYP) ————

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL

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